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D4753-1

Job Sheet 195210



Part No: D4753-1

Job Qty: 75 pcs

Part Name: Doubler



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/15/19

Job Tracking No:

Due Date: 6/18/19

Created By: Jennifer Renwick

Type: Stock

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 13-02-21 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Lead Time	Sign-off
					Setup Hrs	Run Hrs			
100	Waterjet - Flow - 1	75 pcs		6/18/19	0.00	2.25	Waterjet - Flow		06/19/09/12
110	QC 2	75 pcs		6/18/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		06/19/09/12
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		
							QC 2 - 5		
							QC 2 - 71		
120	HAAS 5 Axis - B4B	75 pcs		6/18/19	0.00	5.40	HAAS - 5 - B4B		J.L.V. 19-09-23
140	QC 8	75 pcs		6/18/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		19-09-23
							QC 8 - 25		
							QC 8 - 3		

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					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
150 Small Fab - 2 - B4B	75 pcs	6/18/19	0.00 0.89		Small Fab - 1 - B4B	DAS 58 SEP 25 2019 9-89
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
160 QC 5	75 pcs	6/18/19	0.00 0.00		QC 5 - 10	DAS SEP 25 2019 9-89
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
170 Handfinish - 1-1 Chemical-B4B	75 pcs	6/18/19	0.00 0.62		Handfinish - 1 - 1 - B4B	DAS SEP 26 2019 9-89
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 -	

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180 QC 7	75 pcs	6/18/19	0.00 0.00	B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
				QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	DAS
				QC 7 - 18	61
				QC 7 - 19	9-89
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
190 Packaging 3-1 - Stock - B4B	75 pcs	6/18/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
200 QC 21 - SA	75	6/18/19	0.00 0.00	QC 21 - SA - 21	DAS 21 9-89

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pcs	QC 21 - SA - 70	
	QC 21 - SA - 53	

Part Op 100 - 1-Cut as per Dwg D4753 Dwg Rev: A Prog Rev: A ***.758" DIA HOLE TO BE OPENED TO FIN
 Descriptions: SIZE BY SKID DEPARTMENT UPON INSTALLATION** 3- Deburr if necessary
 110 - QC2- Inspect parts off machine FAI/FAIB
 120 - HAAS CNC Vertical Machine - Machine as per Folio FB163 and Dwg D3506 FOLIO REV: AA DWG
 REV: A ***.758" DIA HOLE TO BE OPENED TO FIN SIZE BY SKID DEPARTMENT UPON INSTALLATION**
 140 - QC8- Inspect parts - second check
 150 - C'sink as per Dwg D4753 (On Flat side)
 160 - QC5- Inspect part completeness to step on W/O
 170 - Chemical Conversion Coat per QSI005 4.1
 180 - QC7-Inspect Chemical Conversion Coat
 190 - Identify as per dwg & Stock Location: LOCATION : LG001
 200 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.125	6061-T6 .125 Sheet	1.0350 sf (.0138 ea)	100-Waterjet - Flow - 1	<u>S1167937</u>

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.125	1	81	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	0.128Inches + 0.005 - 0.001	0.133 0.127	<u>.127</u>	Diameter
2	Doubler	0.500Inches ± 0.010	0.510 0.490	<u>.498</u>	
3	Doubler	1.000Inches ± 0.010	1.010 0.990	<u>1.004</u>	
4	Doubler	0.750Inches ± 0.010	0.760 0.740	<u>.751</u>	
5	Doubler	1.500Inches ± 0.010	1.510 1.490	<u>1.503</u>	
6	Doubler	2.000Inches ± 0.010	2.010 1.990	<u>1.998</u>	
7	Doubler	0.126Inches ± 0.010	0.136 0.116	<u>.120</u>	
8	Doubler	3.540Inches + 0.012 - 0.001	3.552 3.539	<u>3.540</u>	Diameter
9	Doubler	0.126Inches ± 0.010	0.136 0.116	<u>.120</u>	

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Qc 8-20 →

DAS
20
8-89

19-09-23